

Work Order ID 56181

Page 1

February 12, 2010 8:13:15 AM

Item ID:	D3929-042	Accept		Setup	Start		
Revision ID:					Stop		
Item Name:	Gusset Assembly						
Start Date:	2/12/10	Start Qty: 6.00		Cust Item ID:			
Required Date:	2/19/10	Req'd Qty: 6.00		Customer:			
Reference:							
Approvals:	Process Plan: <i>M</i>	Date: <i>10-2-12</i>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3929	A								
100		0.00							
	Waterjet								
FLOW CNC Waterjet	Memo	0.00							
	1-Cut as per Dwg D3929								
	Dwg Rev: <i>A</i>								
	Prog Rev: <i>A</i>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	Memo	0.00							
Quality Control									

*B 10-2-12**(6)**B 10-2-12*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Setup Start



Revision ID:

Item Name: Gusset Assembly

Stop



Start Date: 2/12/10 Start Qty: 6.00



Cust Item ID:

Required Date: 2/19/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

⇒ 316L

(X)



QC

Memo

0.00

Quality Control

130

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

(6)

LPL 10-03-01

140

0.00



Large Fab

Memo

0.00

Large Fab

Weld bushings D3907-1 as per dwg D3929

316L rod batch: M109213

(6)

LPL 10-03-01

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Reference:						
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start
	QC:	Date:	SPC (Y/N):	Date:	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00						6	PD_10.03.01
160 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	8063101					46	
170 Packaging Packaging	Identify as per dwg & Stock Location: <u>basket</u> Memo	0.00 0.00						6	PD_10.03.02

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Cust Item ID:

Required Date: 2/19/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

180



QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Memo

0.00

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Picklist Print

Page 1

February 12, 2010 8:13:20 AM

Work Order ID: 56181



Parent Item: D3929-042



Parent Item Name: Gusset Assembly

Start Date: 2/12/10

Required Date: 2/19/10

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S11GA		Purchased		No		100	sf	81.7878	2.8421		12/10-2-12	

304/316 0.125 Sheet

D3907-1



Bushing

Warehouse

Location

Main Warehouse

MAT

Loc Qty

81.7878

Loc Code

112663

112663

130 Each

62.0000 12.0000

(6)

PL10-03-01

Warehouse

Location

Main Warehouse

WA

Loc Qty

62

Loc Code

1 (1) EPC
1 (3) EPC

54042

21

55104

41

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DART AEROSPACE LTD	Work Order:	SG181
Description: Support Gusset	Part Number:	D3929-1
Inspection Dwg: D3929	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: HB	Audited by: S	Prototype Approval: N/A
Date: 10-2-17	Date: 10/01/16	Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.05.27	New Issue	P/O D3929-041-042	KJ

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NOTE: Date & initial all entries

8

7

6

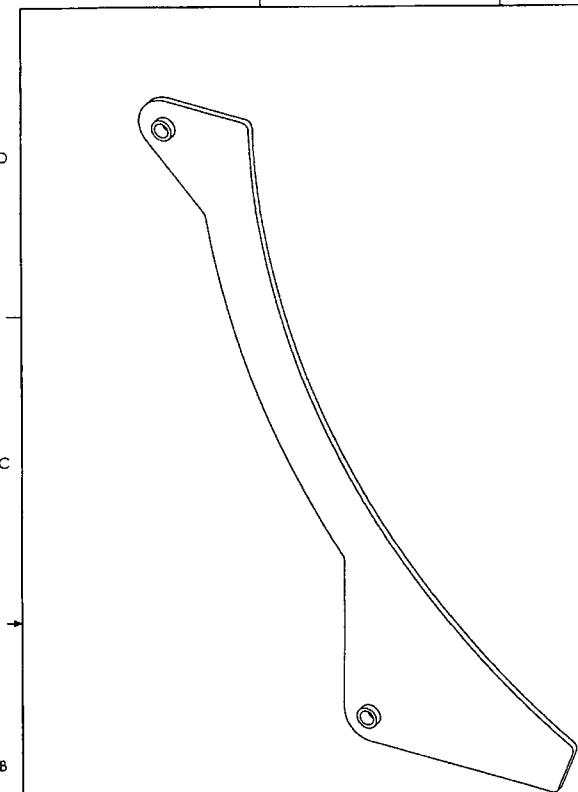
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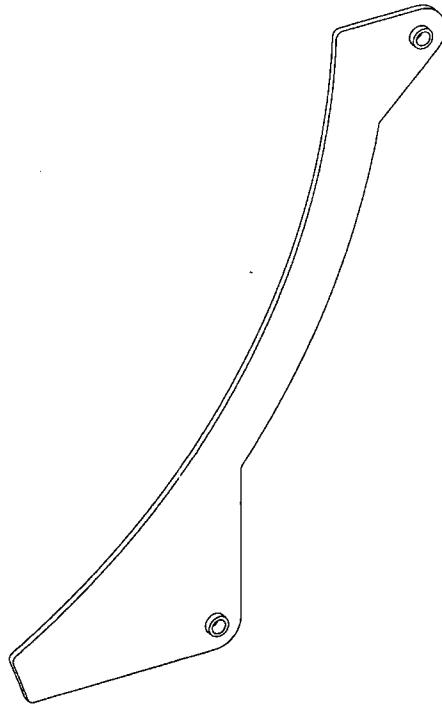
3

2

1



D3929-041 GUSSET ASSEMBLY



D3929-042 GUSSET ASSEMBLY

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 5418

BT 10-2-12

RELEASED
8/10/12 M

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.73 lbs EACH
- 8) WELDING: PER DART QSI 004

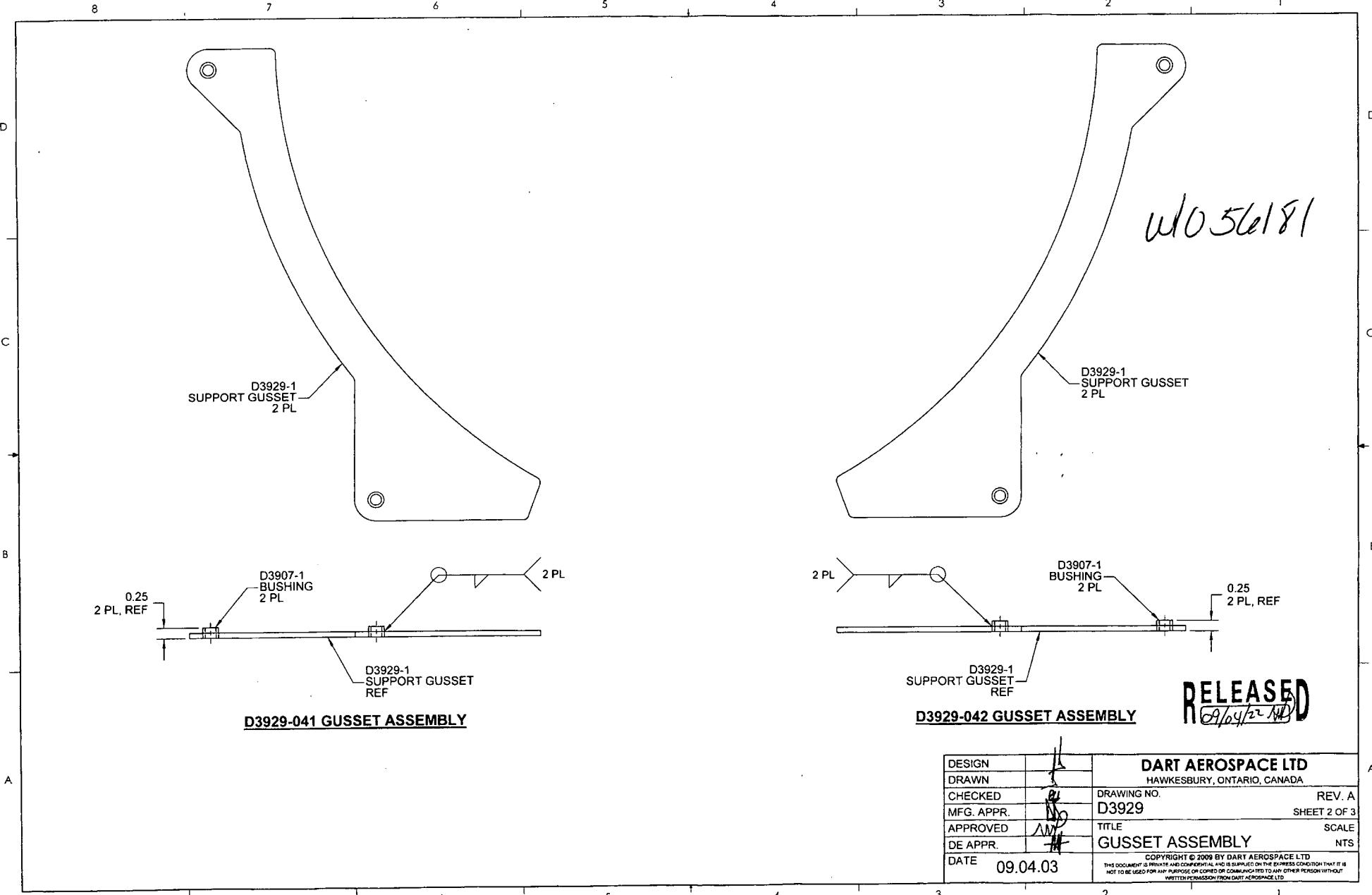
A	NEW ISSUE	MB	09.04.03
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>1</i>		
DRAWN	<i>1</i>		
CHECKED	<i>PA</i>		
MFG. APPR.	<i>MA</i>		
APPROVED	<i>MP</i>		
DE APPR.	<i>MP</i>		
DATE	09.04.03	SCALE	NTS
		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
		DRAWING NO.	REV. A
		D3929	SHEET 1 OF 3
		TITLE	SCALE
		GUSSET ASSEMBLY	
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DESIGN	<i>11</i>	DART AEROSPACE LTD
DRAWN	<i>11</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>11</i>	DRAWING NO.
MFG. APPR.	<i>11</i>	D3929
APPROVED	<i>11</i>	REV. A
DE APPR.	<i>11</i>	SHEET 2 OF 3
DATE	09.04.03	TITLE
		SCALE
		NTS
		GUSSET ASSEMBLY

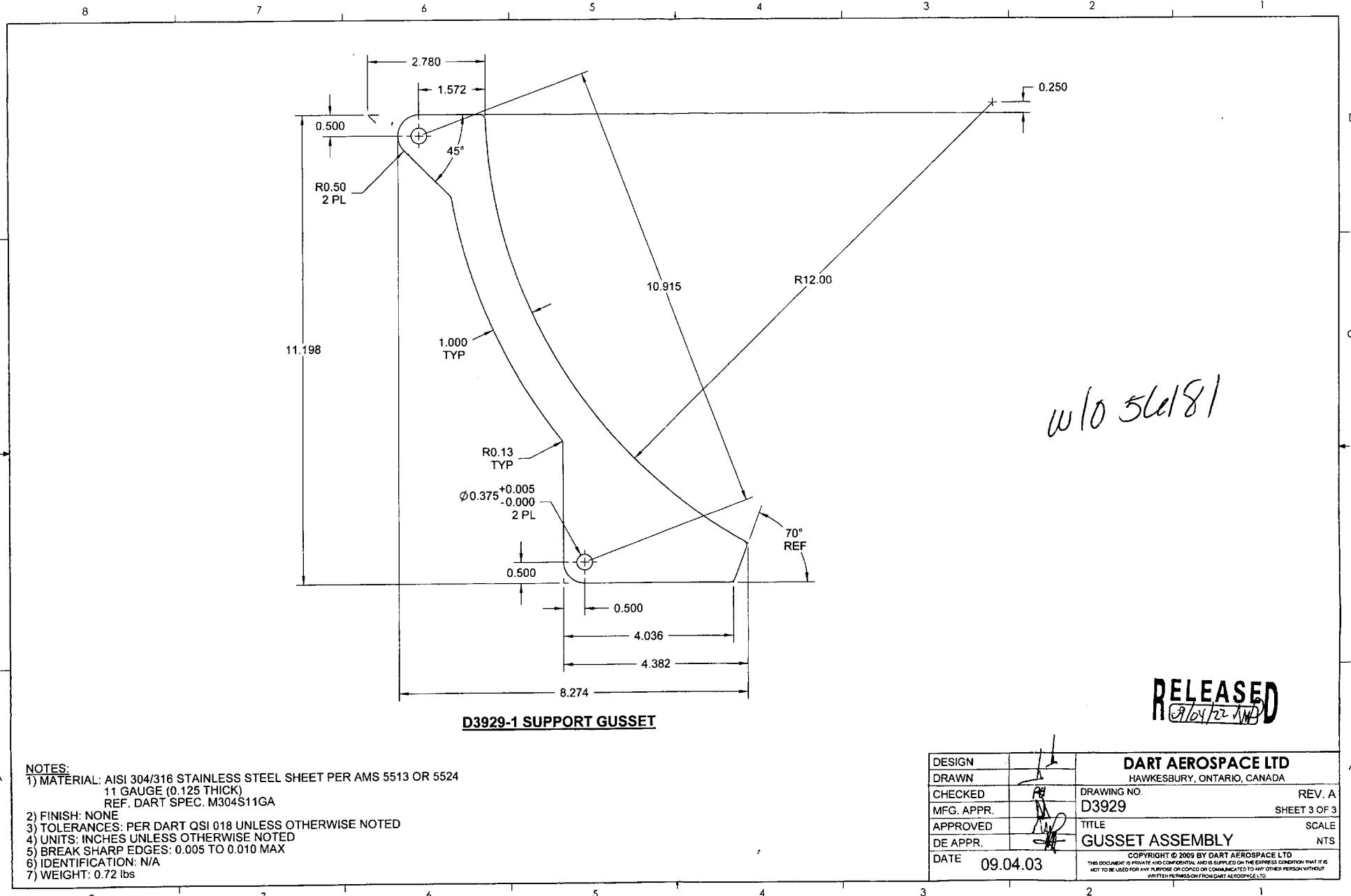
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